

**Work Order ID 68857**

Thursday, April 21, 2011 12:36:33 PM



Page 1

Item ID: D3589-049

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Guide

Start Date: 4/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 1/10/12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3589

Rev B

100

Weld per dwg A/R S.S. rod Batch: M114509 0.00



Large Fab

Memo

0.00

Large Fab

1- assemble and weld as per dwg D3589 QSI004

A/R Stainless Steel rod batch: M114509

11-10-25 X

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



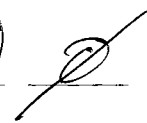
QC

Memo

0.00

Quality Control

11-10-25

(1x) 

120

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

Subs

(1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68857**

Thursday, April 21, 2011 12:36:33 PM



Page 2

Item ID: D3589-049

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Guide

Start Date: 4/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo <i>PP-05504</i>	0.00  0.00							<i>11/10/26</i>
140  QC Quality Control	QC21- Final Inspection - Work Order Release.  Memo	0.00  0.00							<i>11/10/26</i> <i>ME</i> <i>11-10-26</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 12:36:30 PM

Page 1

Work Order ID: 68857

Parent Item: D3589-049

Parent Item Name: Aft Guide



Start Date: 4/21/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-05-30 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3589-19		Manufactured	No			100	Each	3.0000	1	1			
Aft Guide Plate													

Location	Loc Qty	Loc Code
----------	---------	----------

WA023	3	
56916	3	

D3589-5		Manufactured	No			100	Each	2.0000	1	1			
LATCH GUIDE													

Location	Loc Qty	Loc Code
----------	---------	----------

WA023	2	
67082	2	

EL 11/10-25

EL 11/10-25

1

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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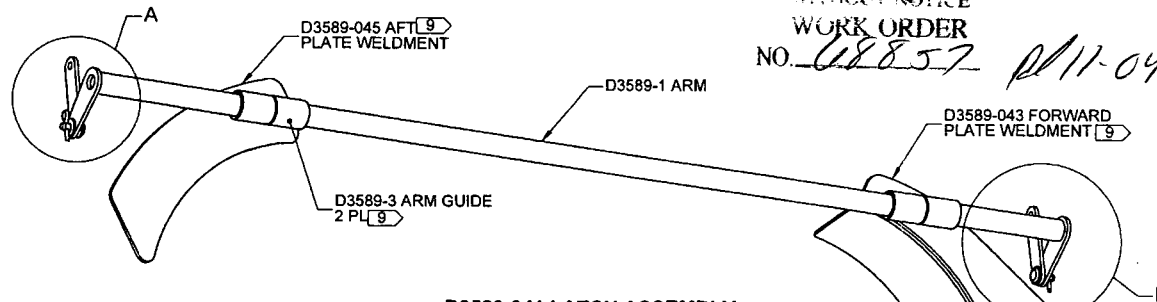
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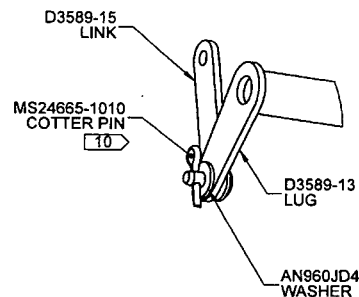
WORK ORDER  
NO. 08857

08/11-04-21

QTY. -041	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY
1	D3589-045	AFT PLATE WELDMENT
1	D3589-043	FORWARD PLATE WELDMENT
1	D3589-1	ARM
2	D3589-3	ARM GUIDE
2	D3589-13	LUG
2	D3589-15	LINK
4	AN960JD4	WASHER
2	MS20392-1C7	PIN
2	MS24665-1010	COTTER PIN

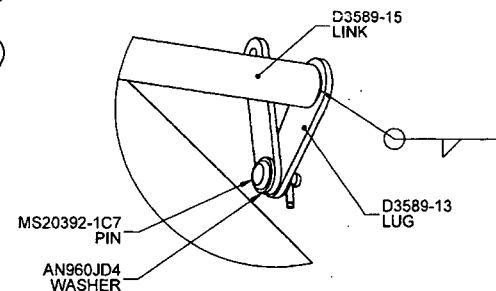


**D3589-041 LATCH ASSEMBLY**



**DETAIL A: LINK ASSEMBLY DETAIL**

SCALE 2X  
2 PL



**DETAIL B: WELDING AND  
LINK ASSEMBLY DETAIL**

SCALE 2X  
2 PL

**RELEASED**  
08/24/05

**D3589-041 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
- 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

B	0.90 AND 0.63 REF WERE 1.97 AND 0.60 (ZN C8-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 29" WAS 15" (ZN B2-2); 18.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-9 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION		MB	08.06.25
A	NEW ISSUE		MB	08.05.29
REV.	DESCRIPTION		BY	DATE
DESIGN	<div>DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA</div> <div>DRAWING NO. D3589</div> <div>TITLE LATCH ASSEMBLY</div> <div>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</div>			
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE			08.06.25	
		REV. B SHEET 1 OF 8		
		SCALE NTS		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

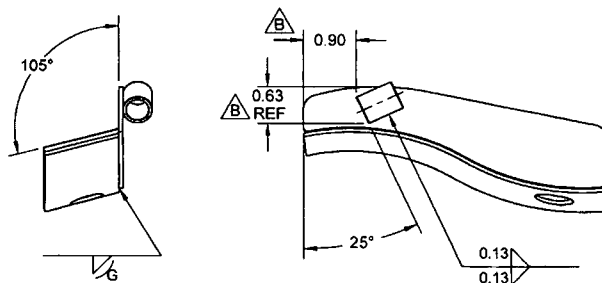
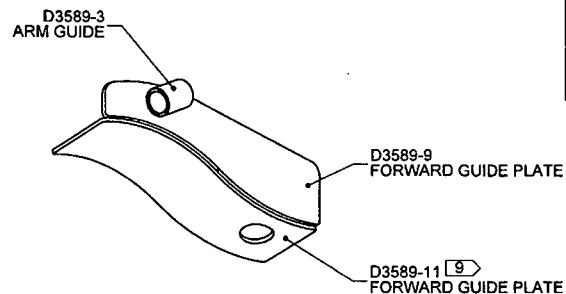
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

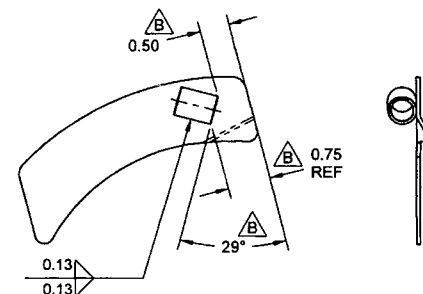
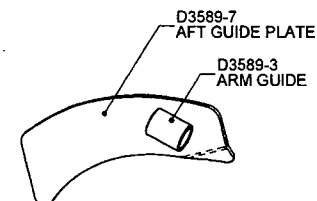
**NOTE:** Date & initial all entries



QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELDMENT
	X	D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE



**D3589-043 FORWARD PLATE WELDMENT**



**D3589-045 AFT PLATE WELDMENT**

u1068857

RELEASED  
09/03/05 N/A

**D3589-043/-045 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
  - D3589-043 = 0.22 lbs
  - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3589</b>	REV. B
MFG. APPR.			SHEET 2 OF 8
APPROVED		TITLE <b>LATCH ASSEMBLY</b>	SCALE
DE APPR.			NTS
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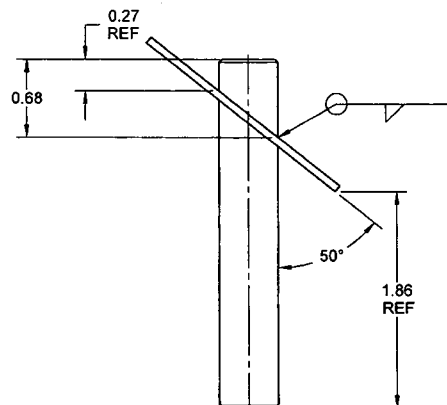
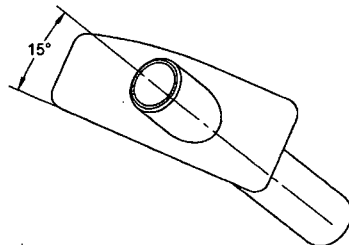
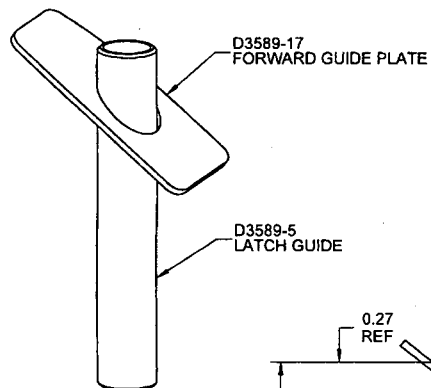
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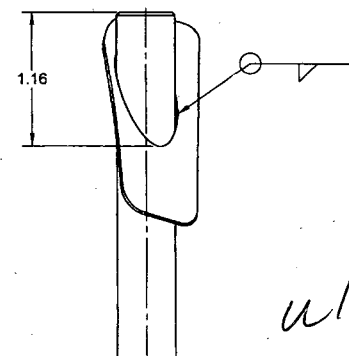
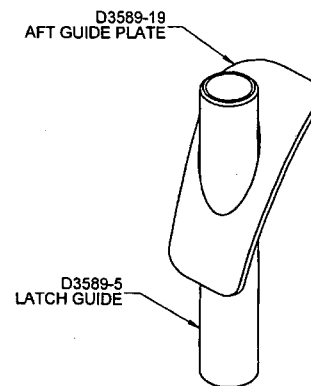
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**NOTE:** Date & initial all entries

QTY -047	QTY -049	P/N	DESCRIPTION
X		D3589-047	FORWARD GUIDE
	X	D3589-049	AFT GUIDE
1	1	D3589-5	LATCH GUIDE
1		D3589-17	FORWARD GUIDE PLATE
	1	D3589-19	AFT GUIDE PLATE



**D3589-047 FORWARD GUIDE**



**D3589-049 AFT GUIDE**

*u106885*

**RELEASED**  
*9/26/09*

**D3589-047/-049 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs EACH
- 8) WELDING: PER DART QSI 004

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DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3589	SHEET 3 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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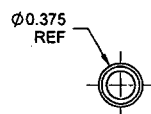
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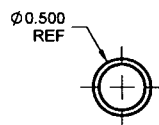


0.03 X 45°  
CHAMFER  
2 PL

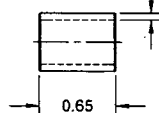


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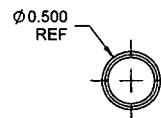
**D3589-1 ARM**



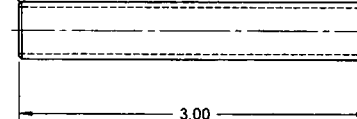
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REF



**D3589-3 ARM GUIDE**



0.03 X 45°  
CHAMFER  
2 PL



0.049  
REF

**D3589-5 LATCH GUIDE**

**D3589-1/-3/-5 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING  
D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)  
D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)  
D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs  
- D3589-3 = 0.01 lbs  
- D3589-5 = 0.06 lbs

DESIGN	<i>JH</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RH</i>	DRAWING NO.	REV. <i>B</i>
MFG. APPR.	<i>SS</i>	<b>D3589</b>	SHEET 4 OF 8
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JH</i>	<b>LATCH ASSEMBLY</b>	NTS
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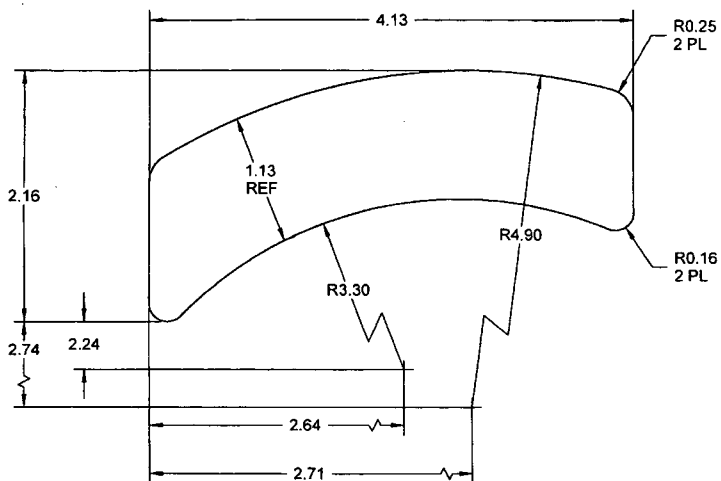
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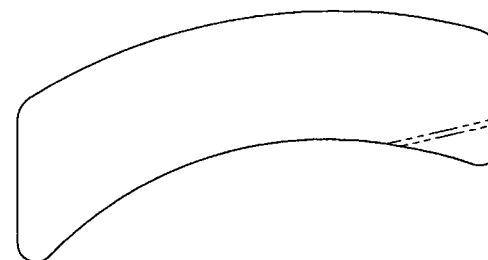
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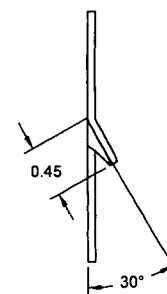
**NOTE:** Date & initial all entries



**D3589-7F AFT GUIDE PLATE  
FLAT PATTERN**



**D3589-7 AFT GUIDE PLATE  
MAKE FROM D3589-7F**



*u/v 68857*

**RELEASED**  
*09/24/15 MB*

**D3589-7F NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524,  
OR MIL-S-5059 (ANNEALED) 2B FINISH  
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D3589</b>	SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>LATCH ASSEMBLY</b>	NTS
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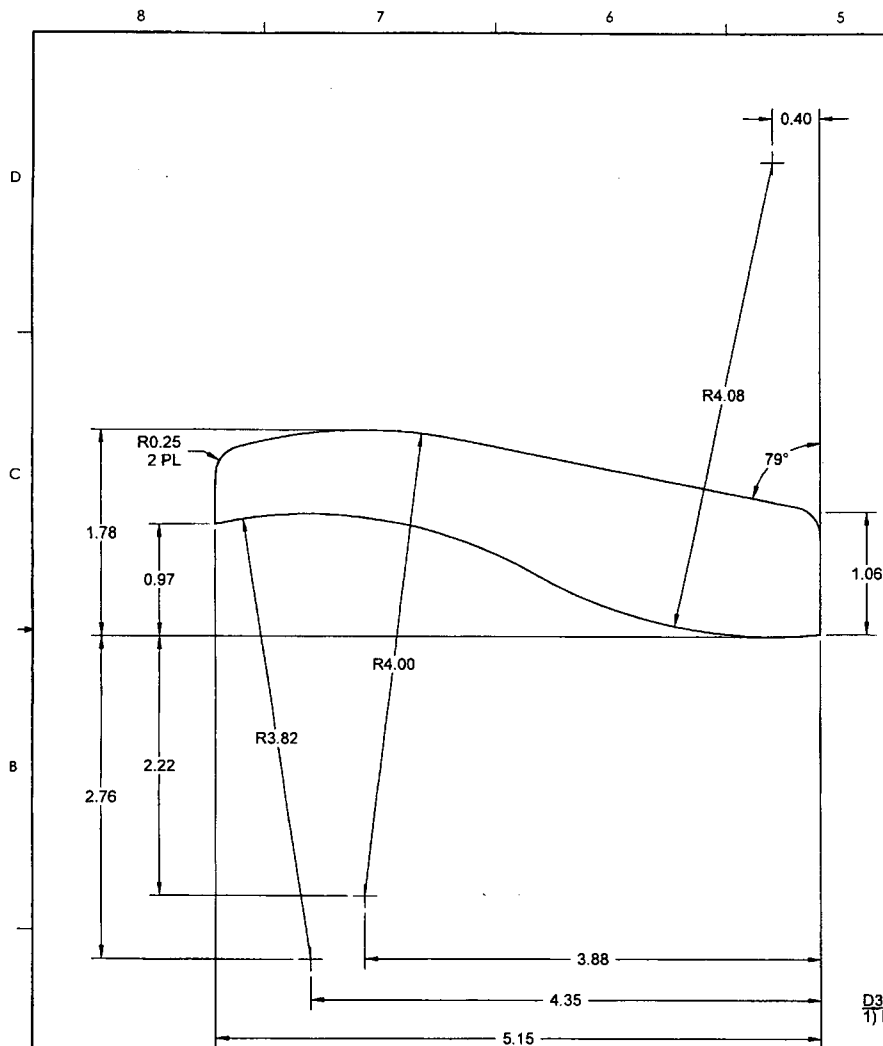
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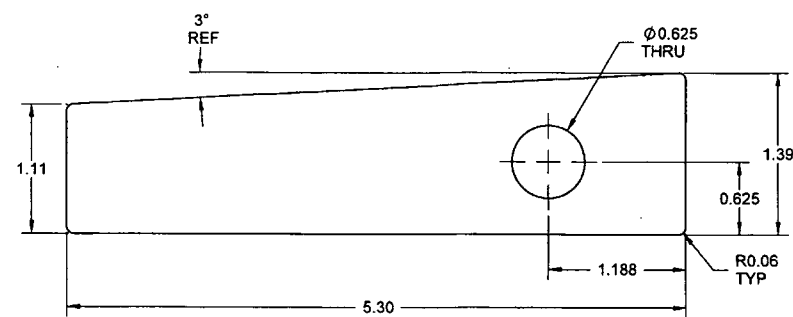
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

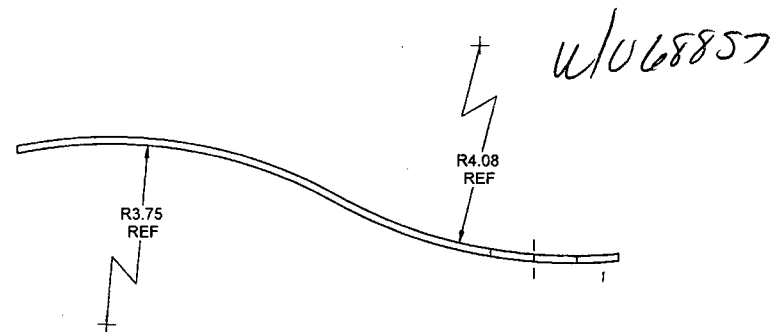




**D3589-9 FORWARD GUIDE PLATE**  $\triangle B$



**D3589-11F FORWARD GUIDE PLATE**  
**FLAT PATTERN**  $\triangle B$



**D3589-11 FORWARD GUIDE PLATE**  
(MAKE FROM D3589-11F)

- D3589-9/-11/-11F NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.09 lbs EACH
  - 8) CONTROL SHAPE PER DT9021 TEMPLATE

**RELEASED**  
9/2/02

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3589</b>	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		<b>FORWARD GUIDE PLATE</b>	NTS
DATE	<b>08.06.25</b>	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

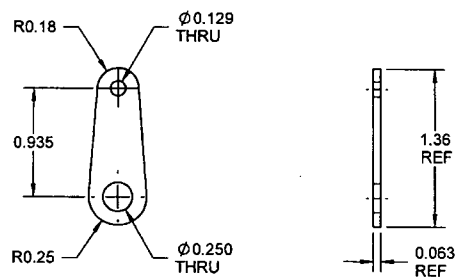
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

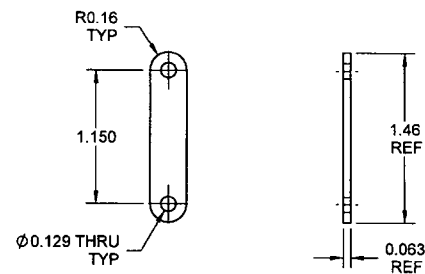
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3589-13 LUG**



**D3589-15 LINK**

*w/o 6885*

**RELEASED**  
*09/02/05 117*

**D3589-13-15 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH  
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

DESIGN	<i>1</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>1</i>	<b>D3589</b>	SHEET 7 OF 8
APPROVED	<i>1</i>	TITLE	SCALE
DE APPR.	<i>1</i>	<b>LATCH ASSEMBLY</b>	NTS
DATE	<b>08.06.25</b>	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

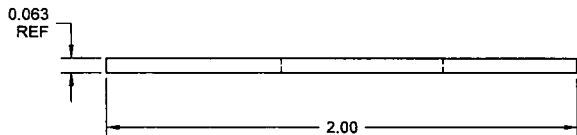
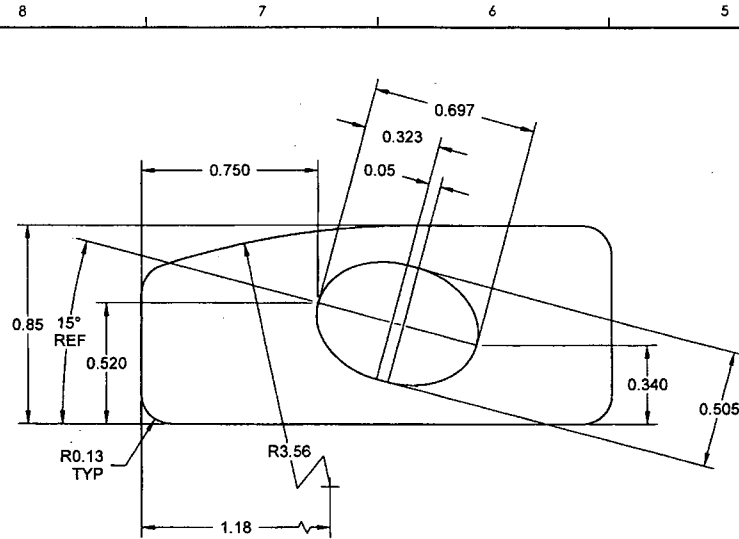
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

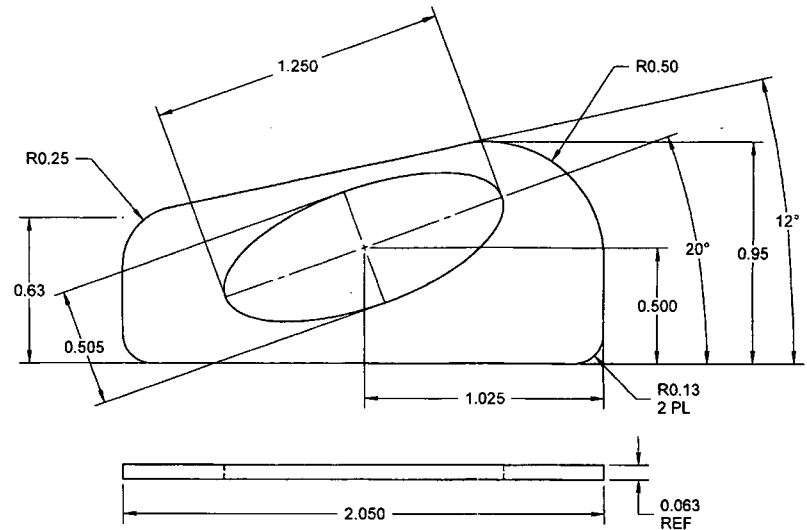
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

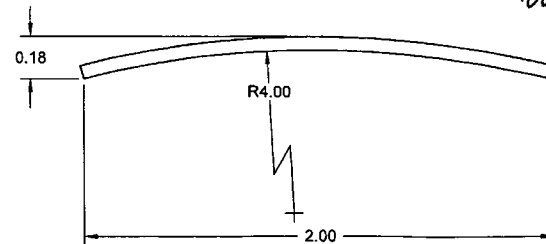
**NOTE:** Date & initial all entries



**D3589-17 FORWARD GUIDE PLATE**



**D3589-19F AFT GUIDE PLATE FLAT PATTERN**



**D3589-19 AFT GUIDE PLATE**  
(MAKE FROM D3589-19F)

**RELEASED**  
09/22/05/11/17

**D3589-17/-19/-19F NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs EACH

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3589</b>	REV. B
MFG. APPR.			SHEET 8 OF 8
APPROVED		TITLE <b>LATCH ASSEMBLY</b>	SCALE
DE APPR.			NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries